

**Work Order ID 61519**

Monday, August 30, 2010 9:19:12 AM



Page 1

Item ID: D3515-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Lid Assembly

Start Date: 8/30/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/6/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3515	Rev A								
100		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1-Cut rib D3515-1 (2) as per dwg D3516 2-Cut rib D3515-3 (2) as per dwg D3516 3-Cut rib D3515-5 (6) as per dwg D3516 4-Cut rib D3515-7 (3) as per dwg D3516 5-Cut Rib (4) D2236 from D3166-3 per dwg D2236								
110		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	Weld assembly as per dwg D3515								
120		0.00							
	QC9- Inspect visual per QSI004- Fusion Welds								
QC	Memo	0.00							
Quality Control									

Pl 11-08-18

Pl 11-08-01

PMB 11/09/07

BE 11-09-07

1 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Item ID: D3515-041

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

140

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

1-Cut expanded metal for base as per dwg D3516 □2-Cut expanded metal for  
base ends as per dwg D3516□3-Weld expanded metal to base as per dwg D3516

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

8/16/07

11-09-07  
PMB 11/09/07BE  
11-09-07

1 φ

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 9/6/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 11/05/08

170

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Powder Coating

Memo

1ST COAT: ☐ START TIME: 9:00 ☐ OVEN

TEMPERATURE: \_\_\_\_\_ ☐ FINISH TIME: \_\_\_\_\_

☐ \*\*\*\*\* 2nd coat if

necessary \*\*\*\*\* ☐ 2ND COAT: ☐ START TIME: \_\_\_\_\_

☐ OVEN TEMPERATURE: \_\_\_\_\_

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

IX ~~Q~~ M/L 11/09/08

1 BL 11-9-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

Wing Walk as per Dwg D3515 and QSI 005 4.4 and spray paint as per  
dwg □ wing walk 118013 □ black spray paint 1118/19

1 BL 11-9-12.

200

0.00



QC3- Inspect Part Finish

QC

Memo

0.00

Quality Control

EP 4/09/12 @

210

0.00



Identify as per dwg &amp; Stock Location: G-A

Packaging

Memo

0.00

Packaging

w/b  
61518

EP 11/09/12 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/13  
MF  
11-09-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

# Picklist Print

Monday, August 30, 2010 9:19:17 AM

Page 1

Work Order ID: 61519

Parent Item: D3515-041

Parent Item Name: Basket Lid Assembly









Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev. A 06.06.05 Preliminary EC  
IPP B 07.04.09 revA dwg EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2232-1  Basket Hinge		Manufactured	No			100	Each	22.0000	2	2			
 B70842 -> ② Pl 11.09.01													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				22					
				55791				22					
D2327-1  Spacer Bushing		Manufactured	No			100	Each	23.0000	2	2			
 B64877 -> ② Pl 11.09.01													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				23					
				54658				11					
				60174				12					
D2506  Label Plate		Manufactured	No			100	Each	4.0000	1	1			
 B71087 -> ① Pl 11.09.01													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				4					
				61174				4					
D2581  Mounting Bracket		Manufactured	No			100	Each	45.0000	2	2			
 B69258 -> ② Pl 11.09.01													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				45					
				60198				10					
				60470				35					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Monday, August 30, 2010 9:19:17 AM

Page 2

Work Order ID: 61519

Parent Item: D3515-041

Parent Item Name: Basket Lid Assembly

Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 1.00

Required Qty: 1.00

D3166-3 Manufactured No

100 Each

11.0418

1 1



Basket Hoop



~~B# 70189~~ ① *pl 11-08-01*

Location

Loc Qty

Loc Code

WA

11.04182105

55697

2.1053E-05

59266

0.0418

60270

5

61193

6

M304EX0.75-16F

Purchased

No

100 sf

811.5923

20

21.05263



Expanded Metal Flat SS



*21.05263* *11/09/07*

Location

Loc Qty

Loc Code

MAT

811.592333

114809

139.403243

114853

11.80059

15012

395.1315

115067

13.0125

115171

7.3394

115401

244.9051

M304TS0.750W.065

Purchased

No

140

f

581.5953

41.5

43.68421



304 SQ Tube .75x.75x.065W



*43.68421* *pl 11-09-01*

Location

Loc Qty

Loc Code

MAT

538.3049

112398

0

114482

1.4628

115494

536.8421

WA

43.290385

114520

11.363385

115274

31.927

*m 118181* *→ 4368421*

Monday, August 30, 2010 9:19:17 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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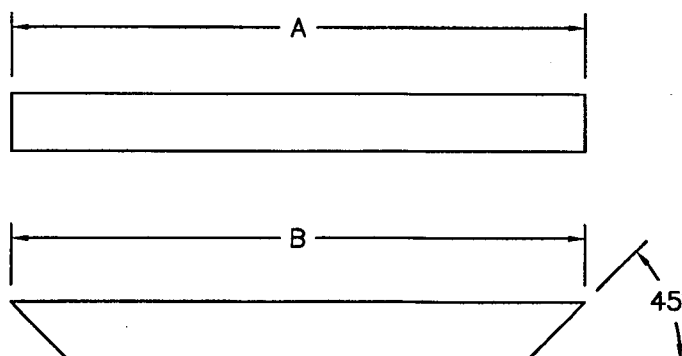
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3515	REV. A SHEET 1 OF 4
DATE 06.05.05		TITLE BASKET LID ASSEMBLY (A119)	SCALE NTS
A	06.05.05	NEW ISSUE	

RELEASED

06.11.17 *[Signature]*

**PARTS LIST FOR D3515-041 BASKET LID ASSEMBLY**

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3515-1	2	—	25.50	RIB
D3515-3	2	—	101.30	RIB
D3515-5	6	33.84	—	RIB
D3515-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 61519  
*[Signature]* 10-8-30

**D3515-1/-3/-5/-7**

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING  
(REF. DART SPECS. M304TS0.750W.065)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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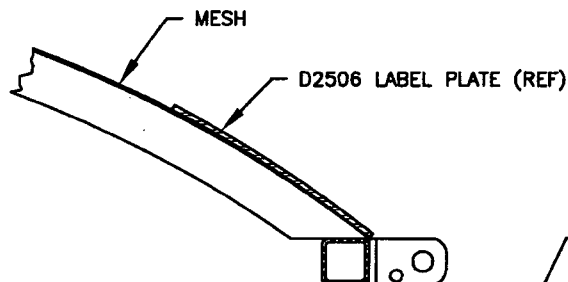
NOTE: Date & initial all entries



**DART**

RELEASED

06.11.17



**SECTION A-A**

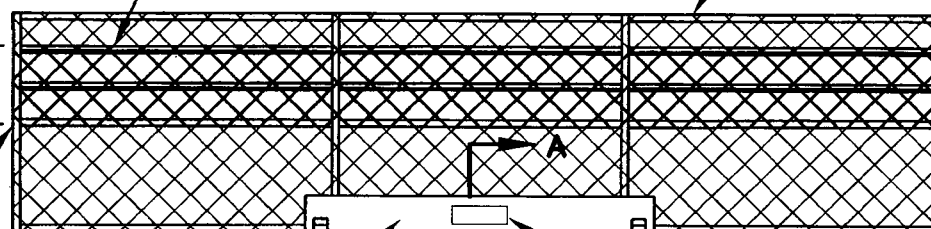
(ROTATED 90° CCW)

FINISH THIS SECTION ALONG  
ENTIRE LENGTH PER NOTE 3  
AFTER POWDER COAT

TACK WELD MESH TO  
FRAME AT EVERY AVAILABLE  
LOCATION IN AREA TO BE  
ANTI SKIDDED

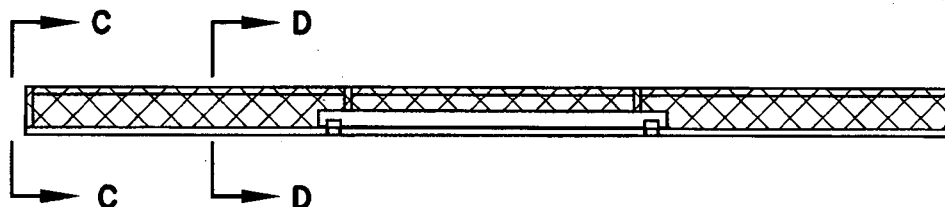
SKIN OUTSIDE SURFACE OF LID WITH  
3/4-16F EXPANDED SS. TACK WELD  
EACH END STRAND TO FRAME

SEE DETAIL B FOR  
FRAME ASSEMBLY



D2506 LABEL PLATE  
CENTER ON THE BASKET

REMOVE 2" X 6" SECTION  
OF MESH FROM BEHIND  
LABEL PLATE



**D3515-041 BASKET LID ASSEMBLY**

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS (REF. DART SPEC. M304EX0.75-16F)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) SPRAY PAINT BLACK INSIDE SURFACE  
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

DESIGN	DRAWN BY	<b>DART AEROSPACE LTD</b>
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	TITLE	REV. A
06.05.05	BASKET LID ASSEMBLY (A119)	SHEET 2 OF 4
		SCALE
		1:20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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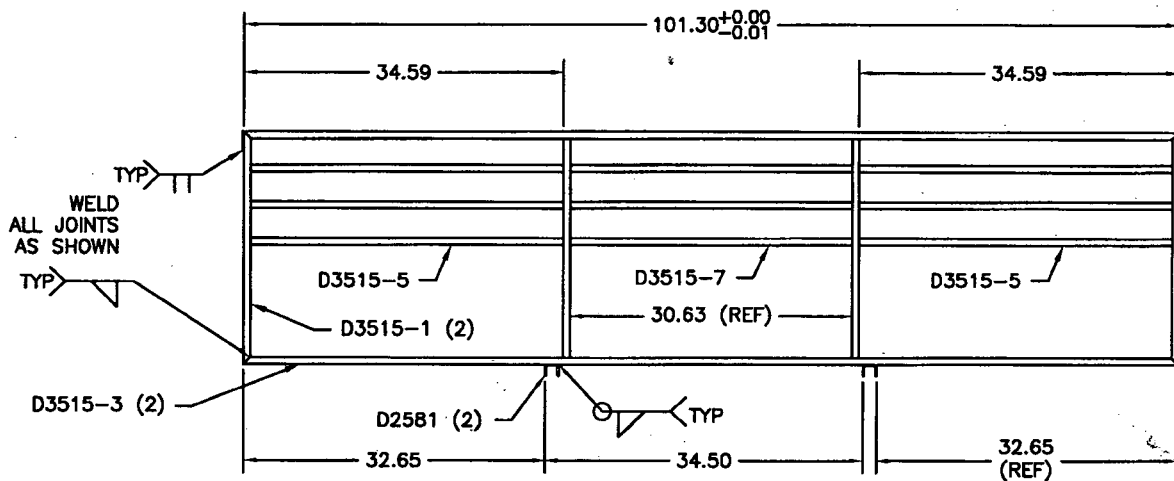
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**DART**

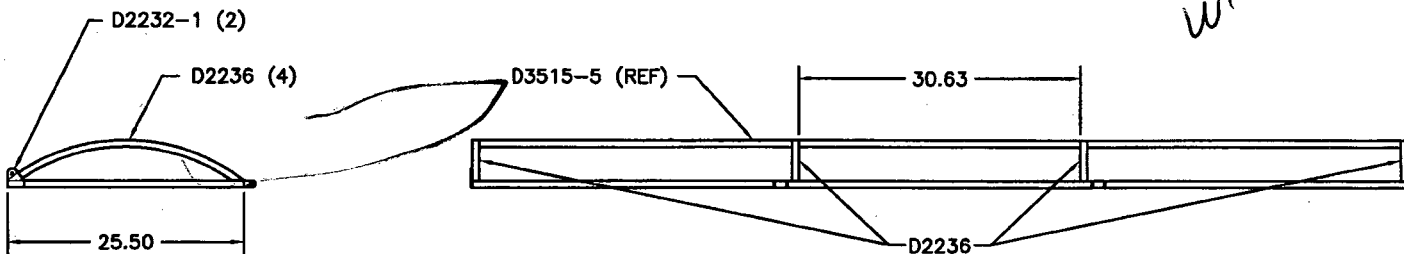
DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	HAMKESBURT, ONTARIO, CANADA	
DATE	DRAWING NO.	REV. A	SHEET 3 OF 4
06.05.05	D3515	SCALE	1:20
	BASKET LID ASSEMBLY (A119)		



**DETAIL B**

FRAMEWORK SHOWN FOR CLARITY  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

*w/06/1519*



RELEASED

06.11.17

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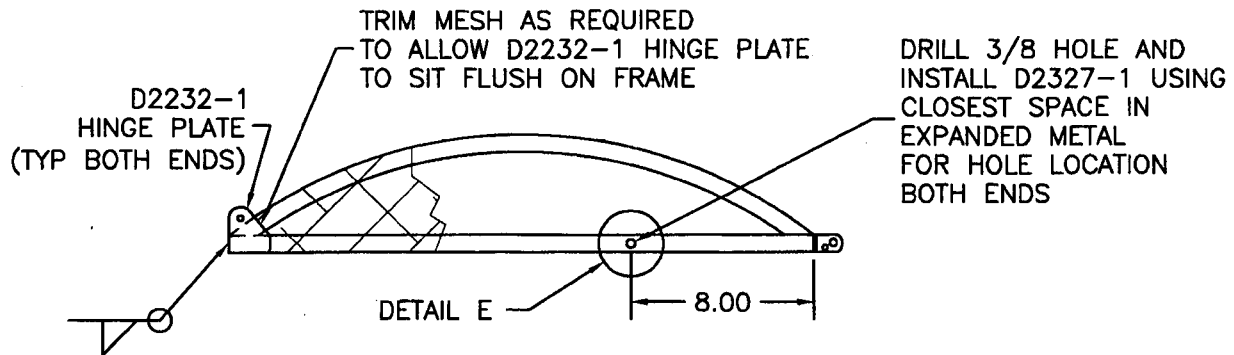
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W/06/15/19

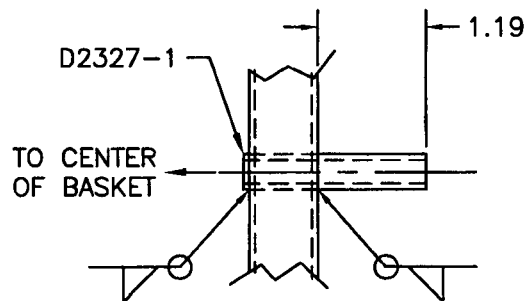
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CHECKED H	APPROVED H	DRAWING NO. D3515	REV. A SHEET 4 OF 4
DATE 06.05.05		TITLE BASKET LID ASSEMBLY (A119)	SCALE 1:8



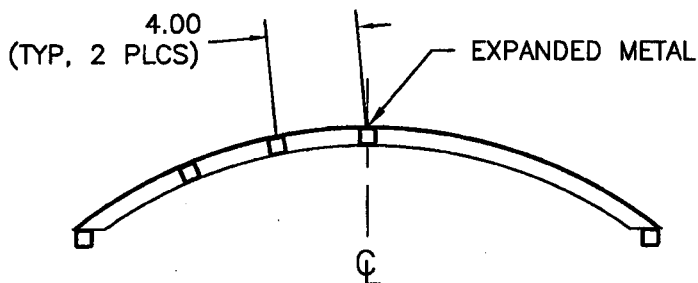
**SECTION C-C SIMILAR BOTH END RIBS**

RELEASED

06-11-17 H



**DETAIL E**



**SECTION D-D SAME BOTH CENTER RIBS**

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries